

Date: Tuesday, 4/25/2006 8:39:22 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MID TUBE ASSEMBLY
Job Number	: 26829		
Estimate Number	: 10469		
P.O. Number	: N/A	Part Number	: D3391023
This Issue	: 4/25/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3391 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26577	Drawing Revision	: D
	Type : LANDING GEAR	Material	: N/A
Written By	: <i>See Comment Below</i>	Due Date	: 5/20/2006
Checked & Approved By	: <i>06.04.25</i>	Qty:	1
Comment	: Est. A 06.10.20 New Issue KJ/EC	Um:	Each
	: Est. B 06.02.10 ECN773 dwg rev.D EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25001100	Skidtube Extrusion
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description
1	D2500-1-100	Extrusion

Batch

*324593**DPob 6-20*

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 as per Dwg D3391

4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.375"

7-Rmove .030" from Fwd indexing Ridge as per Dwg D3391

8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

9-Deburr

10-Drill #30 pilot holes using wearplate Jig DT8217/Identify Ø0.208" holes with paint marker

11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.208" (14 holes) as per Dwg D3391

12-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250" and c'sink (20 holes) as per Dwg D3391

13-Open .375" holes to .438"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 8:39:22 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 26829

Part Number: D3391023

Job Number:



Seq. #: Machine Or Operation:

Description :

114-Deburr and blow out all chips from inside tube

DP 06-6-20

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IT 06-07-07

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/07/15 (1)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-07-07

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty Part Number Description Batch

1 D3389-1 Web *027656*

A/R Sikaflex-241/-291 *M19193*

Sikaflex expire date: *06 11 01*

IT 06-07-07

Start: *060707* Time: *700 am*

Finish: *060708* Time: *700 am*

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

IT 06-07-07

9.0

NAS1330C3KB116

Insert






Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Insert

Pick:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	5.0	Step 5 should be at step 9.		06.07.25			
	13.0	Step 13 should be at step 10.		06.07.25			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 8:39:22 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 26829

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
20	NAS1330C3KB116	Insert	M19349

10.0 NAS1330C3KB166



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

RivnuT

Pick:

Qty	Part Number	Description	Batch
10	NAS1330C3KB166	Insert	M100732

11.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Install inserts as per Dwg D3391

DL 06/07/15 (1)

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

06/07/17 (1)

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/07/15 (1)

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

15.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/25 (1)

Job Completion



06/07/24

Dart Aerospace Ltd

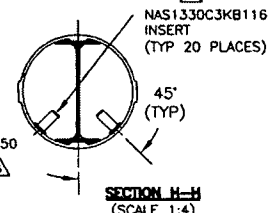
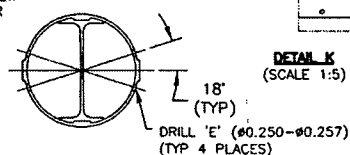
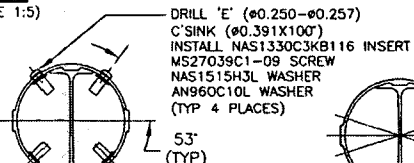
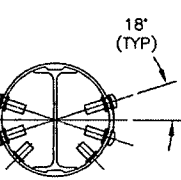
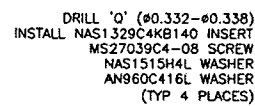
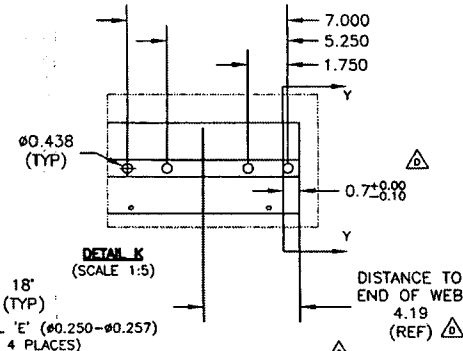
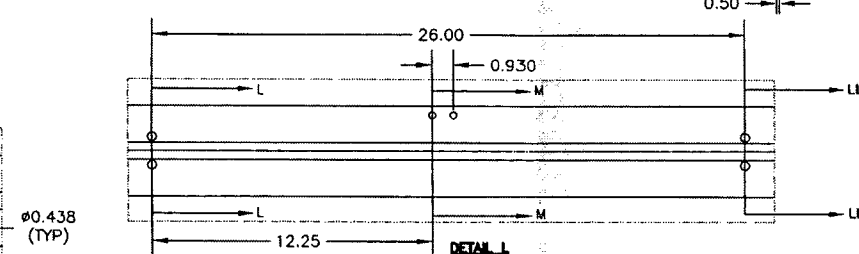
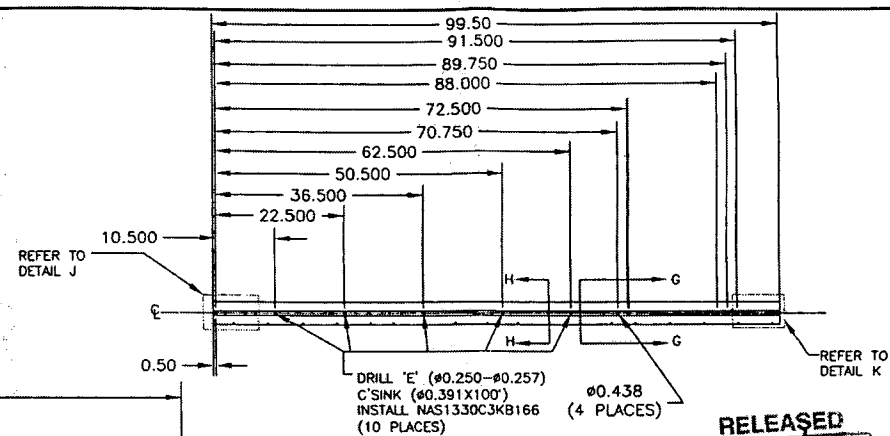
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

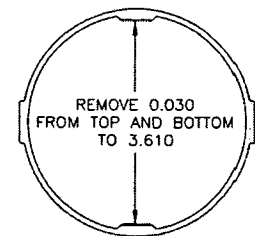
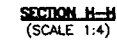
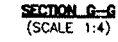
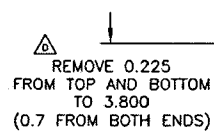
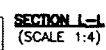
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS 1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS 1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27 039C1-09	SCREW
4		MS27 039C4-08	SCREW

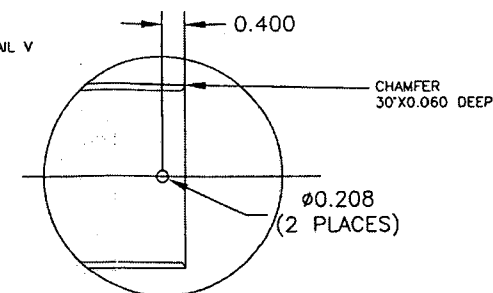
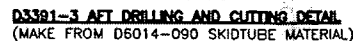
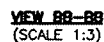


DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO.	REV. D
03391	SHEET 3 OF 5
TITLE	SCALE
412 FLOAT SKIDTUBE	1:20

1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION

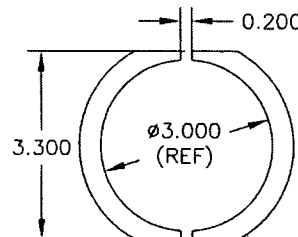
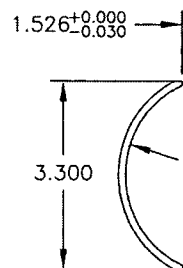
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 WORK ORDER
 26829
 PER QSI 015
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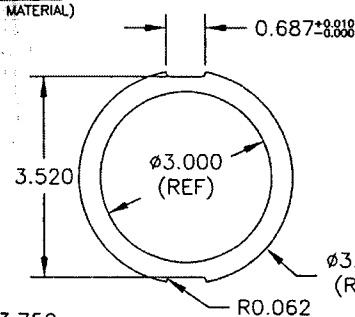
DETAIL V
(SCALE 1:2)

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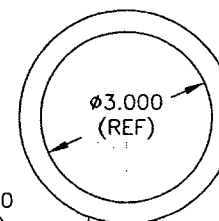
06.01.27



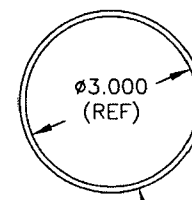
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(SCALE 1:2)



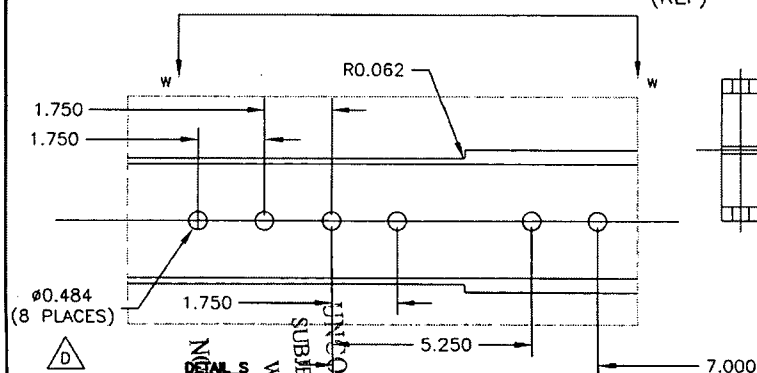
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(SCALE 1:2)



SECTION 0-0
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



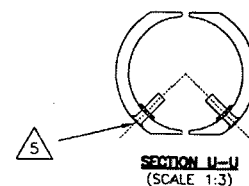
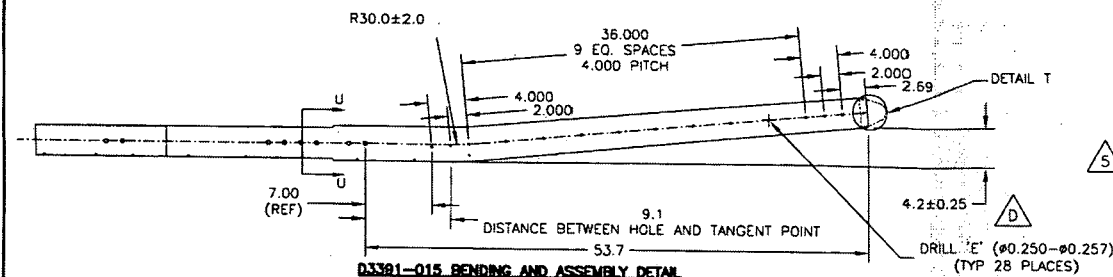
VIEW W-W
(SCALE 1:3)

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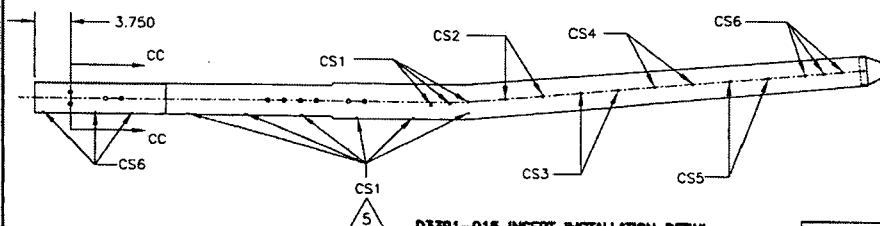
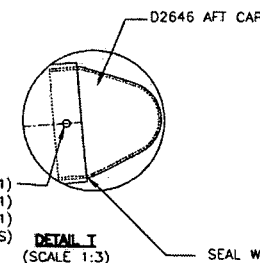
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DESIGN	DRAWN BY	 DART AEROSPACE USA, INC. PORT HADLOCK, WA	
PH	PH	DRAWING NO.	REV. D
CHECKED 	APPROVED 	D3391	SHEET 4 OF 5
DATE	TITLE		SCALE
06.01.23	412 FLOAT SKIOTUBE		1:12

RELEASED
06.01.27



AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)

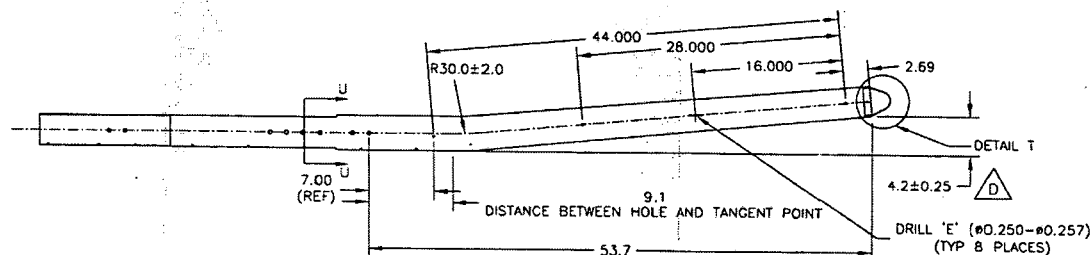


C'SINK AND INSTALL AESS10KBXXX AND/OR
NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS
FOLLOWS

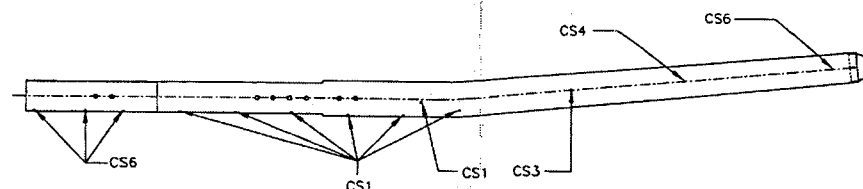
HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB366
CS2	4		Ø0.391	AESS10KB366
CS3	4	2	Ø0.391	NAS1330C3KB316
CS4	4	2	Ø0.391	NAS1330C3KB266
CS5	4		Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

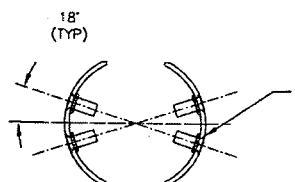
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4		NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4		NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



D3391-025 BENDING AND ASSEMBLY DETAIL



D3391-025 INSERT INSTALLATION DETAIL (SEE TABLE)



SECTION CC-CC
(SCALE 1:3)

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DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3391
DATE 06.01.23	TITLE 412 FLOAT SKIDTUBE	REV. D SHEET 5 OF 5

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